



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D3609-1
Job Sheet 172745



Part No: D3609-1

Job Qty: 8 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 2/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IPP Rev:A New Issue 07-03-26 JLM IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC IPP REV:C AS
PER REV C JLM 11-05-04 VERIFIED BY:DD

Ship Via:

AWG REV E

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	8 Ea		2/21/18	0.00	0.00	Start Up Waterjet		<i>DL 18/03/06</i>
100	Waterjet	8 pcs		2/21/18	0.04	1.17	Waterjet1		<i>DL 18/03/06</i>
110	QC	8 pcs		2/21/18	0.00	0.00	QC2 Waterjet-2		<i>DL 18/03/06</i>
120	QC	8 pcs		2/21/18	0.00	0.00	QC8-3		<i>38</i>
121	Brake NC	8 pcs		2/21/18	0.00	1.87	Brake NC 1		<i>38</i>
122	Small Fab	8 pcs		2/22/18	0.00	1.01	Small Fab-4		<i>MLC DAS</i>
123	QC	8 pcs		2/22/18	0.00	0.00	QC5		<i>38</i>
130	Packaging	8 pcs		2/22/18	0.00	0.00	Packaging3-1		<i>38</i>
140	QC21-SA	8 Ea		2/22/18	0.00	0.00	QC21		<i>38</i>

Part Op 100 - ****PUT PLASTIC BLOCS**** 1-Cut as per Dwg D3609 Dwg Rev: *E* Prog Rev: *E* ***NO SCRATCH
Descriptions: ON TOP SURFACE*** **PLASTIC SURFACE ON TOP*** **KEEP PLASTIC FILM*** 2-Deburr if necessary
110 - ***KEEP PLASTIC FILM***
120 - ***KEEP PLASTIC FILM***
121 - USE DT9760 TOOL ***KEEP PLASTIC FILM***
122 - 1- TRIM AS PER DWG USING GUIDE LINES ***KEEP PLASTIC FILM***
123 - ***KEEP PLASTIC FILM***
130 - ***KEEP PLASTIC FILM***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S22GA4P	304/316 Sheet .032	9.4160 sf (1.177 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S22GA4P	9	21	0

Part Specifications

Specifications could not be found.



Container No: S048440



Part: D3609-1

Job No: 172745

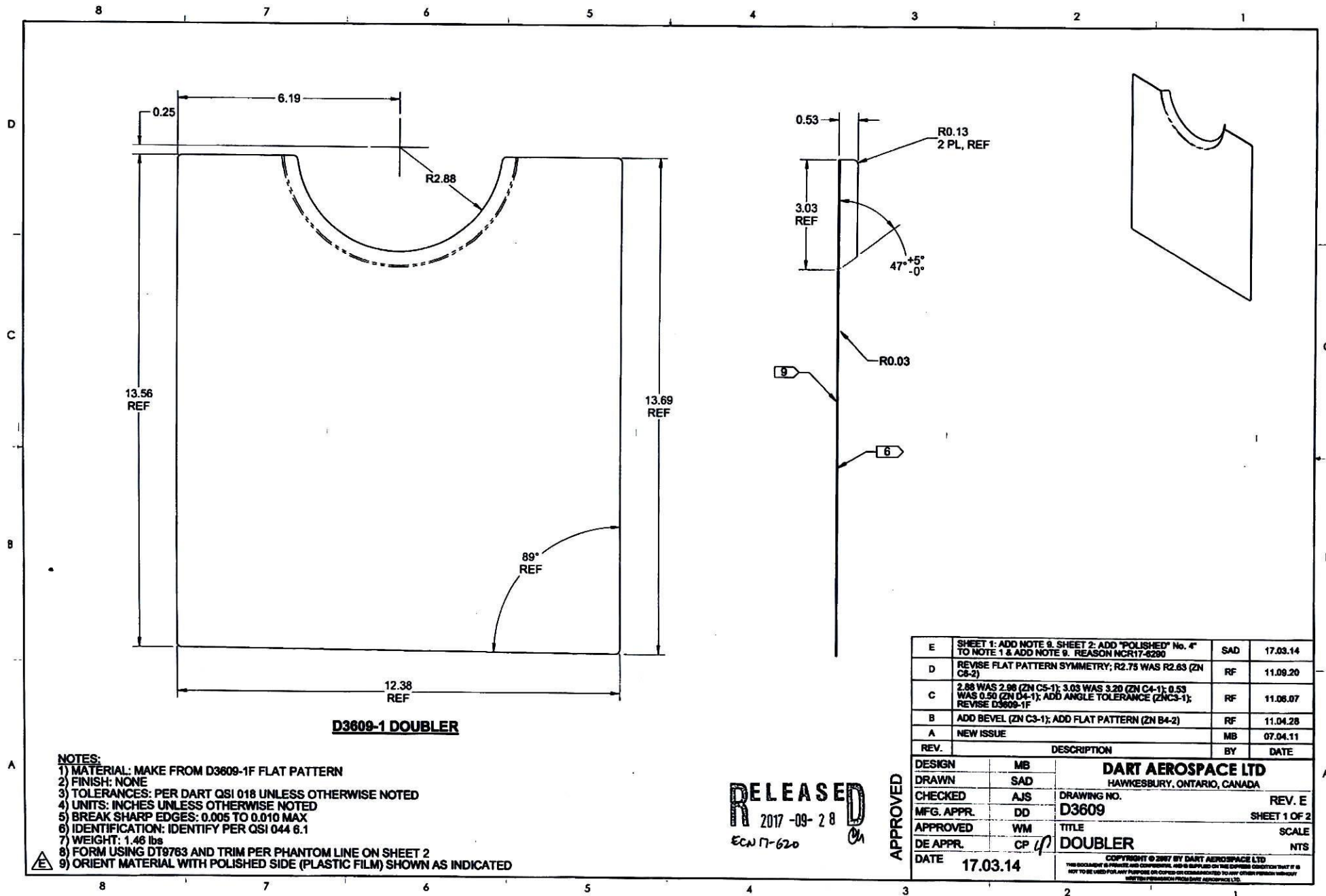
Serial No/Batch: S048440

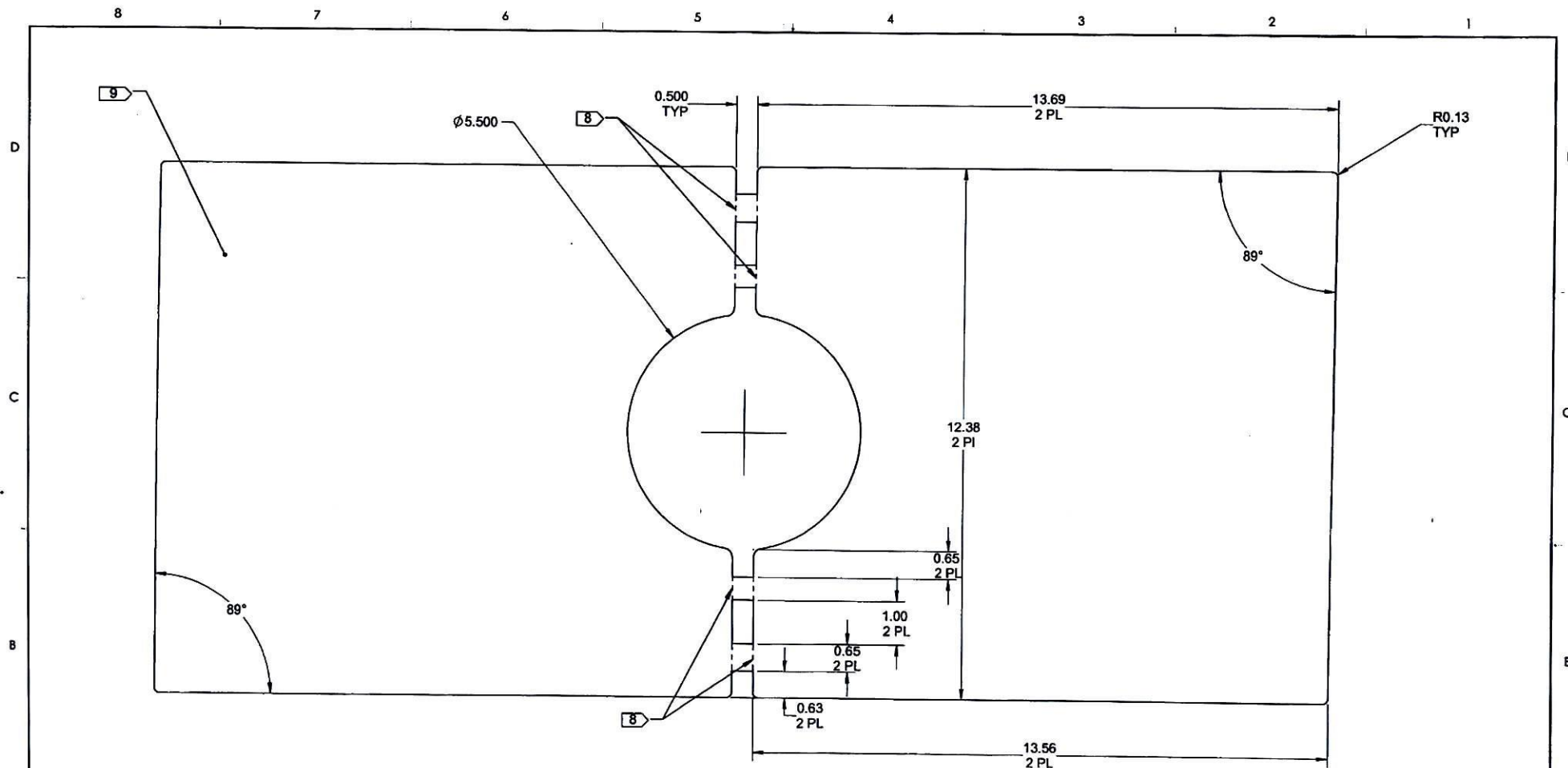
Revision: E

Inspector:

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Date: 03/06/18





D3609-1F FLAT PATTERN
(FLAT PATTERN)
(MAKES 2 PARTS)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED, 22 GAUGE, POLISHED No. 4
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC M304S22GA4P
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.93 lbs
- 8) FORM USING DT9763 AND TRIM PER PHANTOM LINE
- 9) ORIENT MATERIAL WITH POLISHED SIDE (PLASTIC FILM) SHOWN AS INDICATED

RELEASED
2017-09-28

APPROVED

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3609 TITLE DOUBLER DATE 17.03.14	REV. E
DRAWN	SAD		SHEET 2 OF 2
CHECKED	AJS		SCALE
MFG. APPR.	DD		NTS
APPROVED	WM		
DE APPR.	CP		

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